

Date: Wednesday, 09/04/2008 9:18:27 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL		
Job Number	: 38503			Part Number	: D36551		
Estimate Number	: 13101			Drawing Number	: D3655 REVA		
P.O. Number	:			Project Number	: 00204		
This Issue	: 09/04/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 30/04/2008 Qty: 2 Um: Each		
Previous Run	: 37697						
Written By	:						
Checked & Approved By	: <u>JL</u> 08.4.09						
Comment	: Ext. Rev. A 07/12/13						
	Est Rev:B 08-03-06 prototype DD verified by:EC						
	Est Rev:C 08-04-07 revA DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET	
		Comment: Qty.: 3.7134 sf(s)/Unit Total : 7.4269 sf(s) GE PLASTICS LEXAN SHEET batch <u>105494</u> <u>HB 8-4-9</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3655 Dwg Rev: <u>A</u> <u>HB 8-4-9</u> Prog Rev: <u>A</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>HB 8-4-9</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 09/04/2008 9:18:27 AM  
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 38503

Part Number: D36551

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-10

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

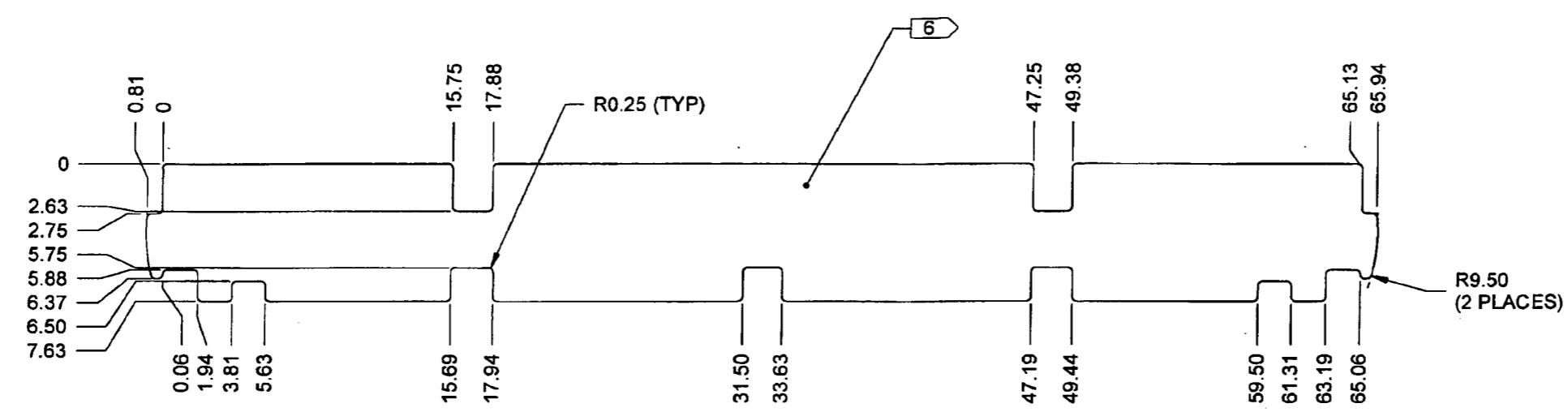
C

B

B

A

A



D3655-1 PANEL

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

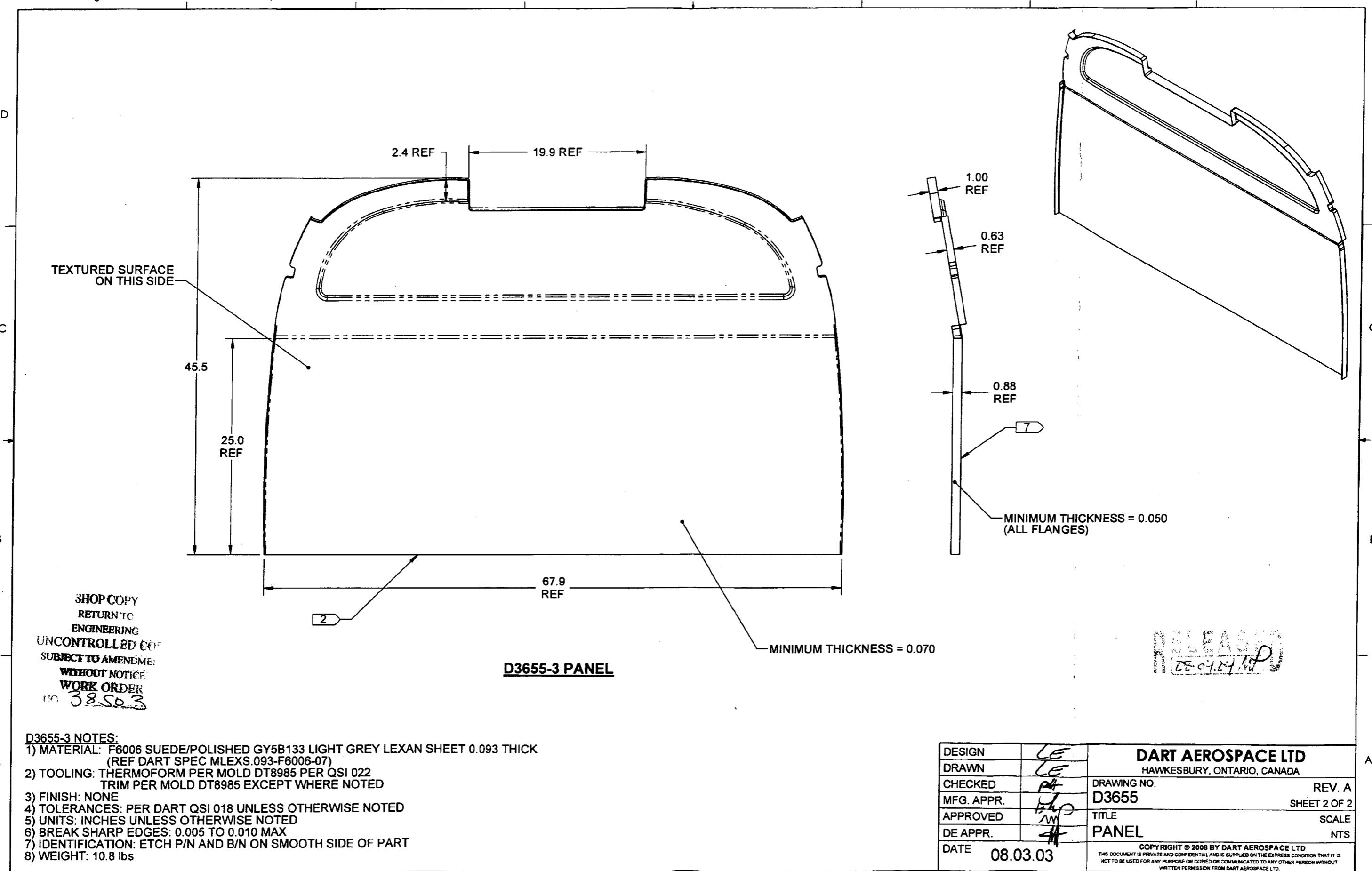
NO. 38503

800404 NP

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	
MFG. APPR.	NP	D3655	REV. A
APPROVED	NP	SHEET 1 OF 2	
DE APPR.	NP	TITLE	SCALE
		PANEL	NTS
DATE	08.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD

Work Order: 38503

Description: PANEL

Part Number: D 3655-1

Inspection Dwg: D 3655-1 Rev: A

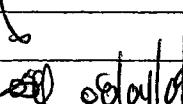
Page 1 of 1

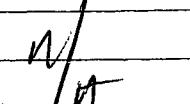
## FIRST ARTICLE INSPECTION CHECKLIST

 First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.63	+.030	2.63	*			
2.75	+.030	2.75	*			
5.75	+.030	5.75	*			
5.88	+.030	5.88	*			
6.37	+.030	6.315	*			
6.50	+.030	6.502	*			
7.63	+.030	7.632	*			
1.94	+.030	1.94	*			
3.81	+.030	3.78	*			
5.63	+.030	5.60	*			
15.69	+.030	15.69	*			
15.75	+.030	15.75	*			
17.88	+.030	17.88	*			
17.94	+.030	17.94	*			
31.50	+.030	31.48	*			
33.63	+.030	33.64	*			
47.19	+.030	47.14	*			
47.25	+.030	47.25	*			
49.44	+.030	49.44	*			
49.38	+.030	49.38	*			
59.50	+.030	59.48	*			
61.31	+.030	61.31	*			
63.19	+.030	63.14	*			

Measured by: KB  
Date: 8-4-9

Audited by:   
Date: 2000-08-04

Prototype Approval:   
Date: 1/1

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	38603
Description: PANEL	Part Number:	D3655-1
Inspection Dwg: D3655-1 Rev: A		Page 7 of 8

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

Measured by:	HS	Audited by:	o	Prototype Approval:	n
Date:	8-4-9	Date:	08/04/09	Date:	14

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

11